



Manufacturing Site Audit Plan

Organisation:	PT Denso Manufacturing Indonesia
Address:	<i>Main site:</i> Kawasan Industri MM2100 Blok FF-3,5,6 Cikarang Barat, Bekasi 17530 Jawa Barat <i>Extended Manufacturing site :</i> Jl. Madura Blok L18, Kawasan Industri MM2100, Desa Cikedokan, Cikarang Barat, Bekasi Jawa Barat 17530
Audit Visit Date:	17-20 February 2025
Audit Due Date	-
Lead Auditor:	A: Ernawati Ahadi
Team Member(s):	B: Adi Koesoema
Audit Language:	Indonesia, English
Witness Auditors, Technical Expert, Translator, Trainee	NA

Time	Auditor	Clients QMS Process Name	Clients Process Owner	QMS PIC (Room)
Date: 17 February 2025				
08.00	ALL	Arrive on client site		
08.30	ALL	Opening meeting, verification of changes to current customer and internal performance data, including a review of current online portals supplier codes, customer reports, and/or customer scorecards. Note for Transfer audits check certificate status issued via the IATF portal	Ms. Hamillah/Mr. I Wayan Harry	-
09.00	ALL	Top Management Discussion: Business Plan, Strategic Planning, Include review interaction with extended site	Mr.Yonanda /Mr.Joko	(Papua Room)
09.30-11.30	A	<i>Management Review, Corrective & Preventive Action, COPQ, Kaizen</i> Include interaction with extended site	QAQP- Mr. Yonanda/Mr.Joko	Mr. Harry (Papua Room)
09.30-11.30	B	Internal Audit	Millah, Adam (Harry) Putri A, Fadhel(Rozi)	Ms. Millah (Jawa Room)
11.30-15.00	A	Customer Satisfaction, Customer complaint handling <i>Include: Interaction/received support process by Denso sales Indonesia for Customer service, warranty management and After Sales Process</i> Verify Customer claim on Body (Sep& Oct 24), Thermal (Nov 24), Wiper washer (Nov 24) CSR: MMKI/ SIM/ ADM/ TMMIN/ Denso Group/ KTB/ JTEK/ HMMI/HPM	QC- Mr. Dony K, Asmet, Yoga QA- Inun, Hardi	Mr. Harry (Jawa Room)
11.30-15.00	B	Marketing Business (Contract Review), Handling New Model, Initial Sample, Customer Approval, ECI, ECR. (Product/process changes), initial product control process, PCN process <i>Review interaction received support of Product Design by DENSO Corporation Motor Business Unit Kosai Plant and Contract Review, Sales & Marketing process from Denso Sales Indonesia.</i>	PC: Mr. Indra, Susanto,Veronica QA: Benny B, Benny R, Kamil, Rofiq, Rizaldy PE : Bayu k, Bayu M, Galih, Naufal QC: Putri,Tri, Fadhel BP: Randy Proc : Fathan, Prio MFG : Bahrul, Erpin, Mahdy	Ms. Millah (Papua Room)

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		CSR: MMKI/ SIM/ ADM/ TMMIN/ Denso Group/ KTB/ JTEK/ HMMI/HPM		
12.00	ALL	Break		
13.00	ALL	Continue morning agenda		
15.00-16.30	A	Record Control, Document Control	Millah, Syifa	Ms. Millah (Jawa Room)
15.00-16.30	B	Customer order and Production Planning & Control	PC- Mr. Andy/Mr. Niam (Galih)	Mr. Harry (Papua Room)
16.30	All	Wrap up Day-1 End of the audit day 1		
Total Audit Day Duration: 1.75 MD (1.75 MD audit day + 0 additional time) Audit days/hours per team member. Lead auditor (A): 0.875 days (7 hours) Co-auditor (B): 0.875 days (7 hours) Hours for auditing of manufacturing process: 0 hours				
Date: 18 February 2025				
07.50	B	Arrive at Extension manufacturing site Jl. Madura Blok L18, Kawasan Industri MM2100, Desa Cikedokan, Cikarang Barat, Bekasi Jawa Barat 17530		
08.00-12.00	B	1 st Shift Component Production process 08.00 – 08.30 : ALL KPI 08.30 – 09.30 : Sub Assembly Stator GA RR Wipper S/A 09.40 – 10.30 : S/A Power seat, 10.30 – 11.30 : S/A Blower 11.30 – 12.00 : Machining Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC, Work Environment	MFG : Toro, Mas eng, Ade/Mr.Yunan PE: Sigit, Deni, Nadhry	Mr. Harry (DMIA 2 Room)
12.00	B	Break		
13.00-14.30	B	Infrastructure maintenance, prod Tooling control	MTN : Mastang MTD : Mr. Nesin, Nunung /Mr.Arik	Mr. Harry (DMIA 2 Room)
14.30-15.00	B	Verify effectiveness of previous NC at extension site (1 minor NC)	Mr. Nesin/Mr.Arik	Mr. Harry (DMIA 2 Room)
15.00	B	Break for Shift 2		
19.30-21.00	B	2 nd Shift component Production process 19.30 – 19.45 ALL KPI 19.50 – 20.20 Injection molding 20.20 – 21.00 metal stamping Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC, Work Environment Include verification shift handover	MFG : Khairul, Sumardi, Ade, Nemin, Misan, Arik, Yunan PE : Angga, makmun, erik, ahady, Nadhry	Mr. Harry (DMIA 2 Room)
21.00	B	Wrap up and end of day 2		
07.50	A	Arrive at Main Site		

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08.00-12.00	A	1 st Shift Production_Wiper Group Wiper System Assembly, 08.00 – 08.30 : ALL KPI 08.30 – 09.30 Motor Link Assy 09.30 – 10.30 wiper motor-BF43 (TR atau Manual) and GP56, 10.30 – 11.30 Wiper system_Assembling Rear Wiper motor (GA Rear) Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC CSR: MMKI/ SIM/ ADM/ TMMIN/ Denso Group/ KTB/ JTEK/ HMMI/HPM	MFG : Bahrul, Marzuki, Husni Hamid, Taufik, M.A Fatoni, Chrys PE : Bayu K, Galih, Runggu, Mukahfid, Kurniadi	Ms. Millah (Papua Room & Genba)
12.00	A	Break/Lunch		
13.00-14.30	A	Production Sub-Assembly: Electronic part Include: Measuring and Monitoring of product, Control of Non Conformance product	MFG : Fajar is, Henri PE : Naufal, Andhika agam, Nadhry	Ms. Millah (Papua Room & Genba)
14.30	A	Break & Waiting shift 2		
19.20	A	Auditor arrived at main site		
19.30-21.00	A	2 nd Shift Production Assembly Power Train Group: 19.30 – 19.45 : ALL KPI 19.45 – 20.15 : EPS Assy #2 (Jalan Line 2 Shift), 20.15 – 21.00 :Throttle Control 30 line 1 & 36 line 4) Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC Include verification shift handover CSR : Denso Group	MFG : Mamin, Timong, simon PE : Bayu M, Andika agam,	Ms. Millah (Papua Room & Genba)
21.00	A	Wrap up and end of day 2		
Total Audit Day Duration: 1.75 MD (1.75 MD audit day + 0.5 hours additional time) Audit days/hours per team member. Lead auditor (A): 0.875 days (7 hours) Co-auditor (B): 0.875 days (7 hours) Hours for auditing of manufacturing process: 12.5 hours (A : 7 hours + B : 5.5 hours)				
Date: 19 February 2025				
07.50	ALL	Arrive on main site		
08.00-12.00	A	1 st Shift Production Assembly: Body Goup 08.00 – 08.30 : ALL KPI 08.30- 09.30 : Power Window BF23 TR 09.40 – 10.40 : GS34, 10.50 – 11.50 : Power Seat	MFG : Mr. Zaen Mahdy, Eko Jarwo, Agung, PE : Naufal, andika agam, Nadhry, Bayu M	Ms. Millah (Papua Room & Genba)

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		Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC <i>Review unachieved target productivity and scrap</i> CSR : Denso Group		
08.00-12.00	B	1 st Shift Production Assembly: Thermal Group: 08.00 – 08.30 : ALL KPI 08.30 – 09.30 : Servo motor Assy, 09.40 – 10.40 : RFC N100 10.50 – 11.50 : Blower Motor Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC CSR : Denso Group	MFG : Fajar is, Aman J, Rukun Bangun, Abdul Wahid, Henri PE : Dhani, Rivaldi, Setyono, Sandy	Mr. Harry (Papua Room & Genba)
12.00	ALL	Break		
13.00-16.00	A	Receiving Part, Supplier Delivery Control, Storage Part	WH : Supriadi, Tubagus S, Windy/Mr.Agusyono QC : Tri, Rozi	Ms. Millah (Papua Room)
13.00-16.00	B	Storage Assy and Shipment (Delivery) Verify logistic Customer complaint Verify interaction support with SIP	Mr. Adi, Supriadi/Mr. Agusyono	Mr. Harry (Papua Room)
16.00 – 16.30	ALL	Verify corrective action effectiveness of previous NC at main site (2 NC minors)	QP : Millah PE : Galih, Agam MFG : Bahrul, Agung J	Ms. Millah (Papua Room)
15.00	ALL	Break and wait 2 nd shift		
19.20	ALL	Arrive on main site		
19.30-21.00	A	2nd Shift Production Assembly: Armature Group 19.30 – 19.45 : ALL KPI 19.45 : 20.15 : Armature Power Seat, Power Window GS, BF23 20.15 : 21.00 : Armature N100 RCF Motor, Wiper Motor, Servo Motor Assy & Armature N100 & Blower. Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC Include verification shift handover	MFG : Cindi, Aspe, MH Makmur, Cecep, Mahdy PE : Wahyu W, Shahadat S, Hamsun, Atha, Fernando	Ms. Millah (Papua Room & Genba)
19.30-21.00	B	1 st Shift Production Assembly: Washer System Production 19.30 – 19.45 : ALL KPI 19.45 – 20.15 : Motor BT17 20.15 – 21.00 : Washer Tank & Hose Assy Include: Measuring and Monitoring of product, Control of Non Conformance product, SPC <i>Review unachieved target productivity and scrap</i> CSR: MMKI/ SIM/ ADM/ TMMIN/ Denso Group/ KTB/ JTEK/ HMMI/HPM	MFG: Supono, Taufik, Hamid, Chrys PE : Bayu S, Bayu K, Mukhafid, Kurniadi	Mr. Harry (Papua Room & Genba)
20.30	ALL	Wrap up and end of day 3		

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Total Audit Day Duration: 1.75 MD (1.75 MD audit day + 0 hours additional time) Audit days/hours per team member. Lead auditor (A) : 0.875 days (7 hours) Co-auditor (B): 0.875 days (7 hours) Hours for auditing of manufacturing process: 6 hours (A : 3 hours + B : 3 hours)				
Date: 20 February 2025				
07.50	ALL	Arrive on main site		
08.00-11.00	A	Procurement Sourcing, Purchase Order (part), Supplier performances, Custom Clearance Import. Include verify interaction support Supplier Management from DNIA Bekasi Plant	Proc : Mr. Sugiarto Agung, Ridwan, Fathan QC : Erni, Lubis, Hendra PC : Galih/ Cristin	Ms. Millah (Papua Room)
08.00-11.00	B	Control of Measuring and Monitoring Device (Laboratory), MSA	Mr. Masrul, Suhardi/Mr. Danan	Mr. Harry (Jawa Room)
11.00	ALL	Report preparation		
12.00	ALL	Break		
13.00	ALL	Continue report preparation		
16.00	ALL	Closing meeting		
Audit Day Duration: 2 MD (2 MD audit day + 0 day additional time) Audit days/hours per team member. Lead auditor (A): 1 day (8 hours) Co-auditor (B): 1 day (8 hours) Hours for auditing of manufacturing process: 0 hour				
Total Audit Day Duration: 8.1875 MD (8 MD audit day + 0.1875 day additional time) Total Audit days/hours per team member. Lead auditor (A): 4 days (32 hours) Co-auditor (B): 4 days (32 hours) Total Hours > 30% for auditing of manufacturing process: 25.5 hours				
Total Additional Audit Hours: 1.5 hours >= 0.5 hour per minor n/c: 1.5 hours 1-3 hours per major n/c: None Audit Planning time (max 2): 0 hours Investigation of IATF OEM quality and delivery requirements: None Scope changes: None Translation time: None Technical Expert: None Additional hours per team member. Lead auditor (A): 0.5 hours Co-auditor (B): 1 hours Notes Rules 5.7.2 j) the total additional audit time per auditor and for the entire audit to be specific in the audit plan. Rules 5.2 m) maximum calendar audit day is 10 hours per auditor (8 hours audit day + 2 additional audit hours). Rules 5.2 breaks & travel time between clients locations shall be excluded from the audit time & additional time. Rules 5.2 j) max 15% of the audit day can be allocated to draft report writing in CARA which includes optional daily wrap-up/debrief meetings.				

Notes to Client:

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- SGS auditors reserve the right to change or add to the elements listed before or during the audit depending on the results of on-site investigation.
- A private place for preparation, review and conferencing is requested for the auditor's use.
- Please provide a light working lunch on-site each audit day.
- Your contract with SGS is an integral part of this audit plan and details confidentiality arrangements, audit scope, information on follow up activities and any special reporting requirements.

Audit Plan Changes

Issue	Date	Changes
1	06/01/25	First issue from the off-site planning & auditor review of the APC of the organization submitted data, IATF rules 5.7.2 at least 14 calendar days before start date
2	13/02/25	Revise MD due to wrong calculation MD
3		

Verification of QMS Processes over the 3-year cycle

- QMS Process
- On site (Remote Support Location)
- Off site (Standalone Remote Support Location)
- Manufacturing processes on all Shifts
- CSR's

Process Description	Audit Cycle					
	Initial / Recert	1 st Surv	2 nd Surv	Recert		
Business Plan, Strategic Planning	X	O	O	O		
Management Review, Corrective & Preventive Action, COPQ	X	O	O	O		
Customer Satisfaction, Customer complaint handling Interaction with Denso sales Indonesia for customer service & warranty management	X	O	O	O		
Internal Audit	X	O	O	O		
Procurement Sourcing, Purchase Order (part), Supplier performances, Customer Clearance Import	X	O		O		
Marketing Business (contract review), Handling New Model, , Initial Sample, Customer Approval, ECI, ECR (Product/process changes), initial product control process, PCN process Review interaction with RL/Supporting process. (DNIA, DN Kosai).	X	O	O	O		

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Control of Measuring and Monitoring Device (Laboratory), MSA	X	O		O		
HR recruitment, Training Dojo, HR Development (Motivation & Empowerment)	X		O	O		
Receiving Part, Supplier Delivery Control, Storage Part	X	O		O		
Customer order and Production Planning & Control	X	O		O		
Record Control, Document Control	X	O		O		
Storage Assy and Shipment (Delivery)	X	O		O		
Measuring and Monitoring of product	X	O	O	O		
Control of Non Conformance Product	X	O	O	O		
SPC	X	O	O	O		
Work Environment	X		O	O		
Infrastructure maintenance	X		O	O		
Customer Payment and Supplier Payment	X		O	O		
Workshop & Prod Tooling control	X		O	O		
Kaizen	X		O	O		
Manufacturing Process Name & Operational Shifts_ Main site						
Production_Wiper Group (Wiper System Assembly, Motor Link Assy front wiper motor-BF43 and GP56, Wiper system_Assembling Rear Wiper motor (GA Rear & N3) 2 Shift	X S1,2 1 Mi	O S1	O S2	O S1,2		
Production Assembly: Power Train Group (EPS Assy, Throttle Control 30&36) 2 Shift	X S1,2 1 Mi	O S2	O S1	O S1,2		
Sub Assy (Electronic Part) 1 shift	X S1	X S1	O S1	O S1		
Production Assembly: Washer System Production (Washer	X S1,2	O S2	O S2	O S1,2		

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system including: Motor BT17 and Hose Assy)						
Production Assembly: Body Group (Power Window BF23 TR & GS34), Power Seat 2Shift	X S1,2	O S1	O S2	O S1,2		
Production Assembly: Thermal Group: Servo motor Assy, RFC N100, Fan Blower W/Shroud 2Shift	X-1Min S1,2	O S1	O S2	O S1,2		
Production Assembly: Armature Group: Power Seat, Power Window GS & BF23, N100 RCF Motor, Wiper Motor, Servo Motor Assy & Armeture N100 & Blower. 2 Shift	X-2Min S1,2	O S2	O S2	O S1,2		
SITE EXTENSION						
Production process Injection moulding 2Shift	X S1,2	O S2	O S1	O S1,2		
Production Metal Stamping 2 Shift	X S1,2	O S2	O S1	O S1,2		
Sub Assembly (Stator GA RR Wipper S/A, S/A Power seat, S/ABlower) 2 Shift	X S1,2	O S1	O S2	O S1,2		
Production: Machining 1 Shift	X S1	O S1	O S1	O S1,2		
Receiving Part, Storage Part, Storage and Delivery	X		O	O		
Infrastructure maintenance, workshop & prod Tooling control	X 1 Mi	O		O		
Name and Location of Support Function (only Option 1 or CSF)						
NA (No option 1/CSF)						
Customer Specific Requirements audited in this visit						
Toyota (TMMIN)	X		O			
Daihatsu (ADM)	X		O			

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Suzuki (SIM)		O				
Suzuki Motor Thailand		O				
Hino (HMMIN)		O				
Mitsubishi	X	O				
Honda (HPM)	X		O			
Denso group	X	O	O			
PT. ANI /Aisan NDenso Manufacturingco Industry	X					
Aisin Indonesia Automotive		O				
Krama Yuda Tiga Berlian		O				
PT. JTEKT Indonesia	X		O			

For planned visits, indicate with an "O" in the box for each process / RL / CSR to be planned

For completed visits, mark "X" in the box for each process completed

Track nonconformities, note the number of minors and/or majors identified in each process at every visit

For planned visits, indicate with an "O" in the box for each process to be planned

For completed visits, mark "X" in the box for each process completed

Track nonconformities, note the number of minors and/or majors identified in each process at every visit

Shift 1	07.00 – 19.00
Shift 2	19.00 – 07.00

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